

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018525**Date Inspected:** 03-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (11AW-11BW)

This QA Inspector witnessed the final bolt tension verification on the U-rib of segment 11AW to 11BW. The torque wrench S/N was XO2-776. The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance with the contract specifications. The panel point and bolt size designations were as follows:

PP 97 to PP 98:

M22 X 65 – DHGM 220116– 333 NM

For additional information please reference the pictures below:

OBG # TRIAL ASSEMBLY YARD (11AW-11BW)

This QA Inspector witnessed the final bolt tension verification on the WT stiffeners of segment 11AW to 11BW. The torque wrench S/N was XO2-776. The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance with the contract specifications. The panel point and bolt size designations were as follows:

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PP 97 to PP 98:

M22 X 65 – DHGM 220116– 333 NM

M22 X 70 – DHGM 220038– 480 NM

For additional information please reference the pictures below:

OBG # TRIAL ASSEMBLY YARD (11AW-11BW)

This QA Inspector witnessed the final bolt tension verification on the longitudinal diaphragm of segment 11AW to 11BW. The torque wrench S/N was XO2-676. The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance with the contract specifications. The panel point and bolt size designations were as follows:

PP 97 to PP 98:

M24 X 70 – DHGM 240075– 680 NM

M24 X 95 – DHGM 240021– 540 NM

OBG # TRIAL ASSEMBLY YARD (11AE-11BE)

This QA Inspector witnessed the final bolt tension verification on the U-rib of segment 11AW to 11BW. The torque wrench S/N was XO2-666. The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance with the contract specifications. The panel point and bolt size designations were as follows:

PP 97 to PP 98:

M22 X 65 – DHGM 220116– 333 NM

M22 X 80 – DHGM 220094– 470 NM

M22 X 65 – DHGM 220121– 393 NM

OBG # TRIAL ASSEMBLY YARD (11AE-11BE)

This QA Inspector witnessed the final bolt tension verification on the WT stiffeners of segment 11AW to 11BW. The torque wrench S/N was XO2-666. The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance with the contract specifications. The panel point and bolt size designations were as follows:

PP 97 to PP 98:

M22 X 65 – DHGM 220116– 333 NM

M22 X 70 – DHGM 220038– 480 NM

OBG # TRIAL ASSEMBLY YARD (11AE-11BE)

This QA Inspector witnessed the final bolt tension verification on the longitudinal diaphragm of segment 11AW to 11BW. The torque wrench S/N was XO2-666. The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance with the contract specifications. The panel

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point and bolt size designations were as follows:

PP 97 to PP 98:

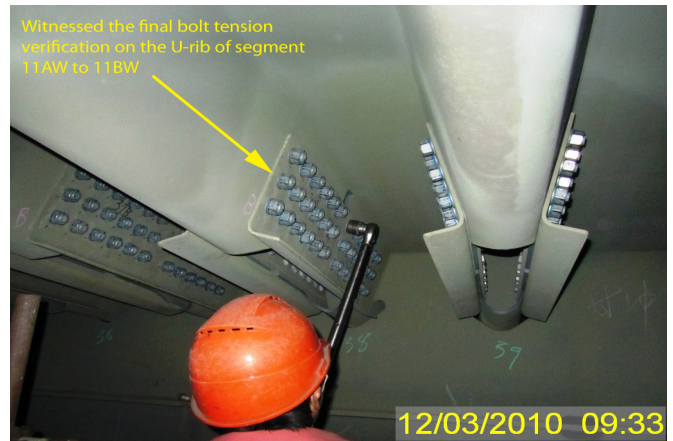
M24 X 70 – DHGM 240010– 560 NM

M24 X 95 – DHGM 240021– 540 NM

OBG # TRIAL ASSEMBLY YARD (11DW-11EW)

This QA Inspector along with QA Inspector Mr.Manjunath S Math performed dimensional joint survey inspection on the longitudinal diaphragm to verify the offset and sweep using 1000mm straight edge and string line. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 11DW to Segment 11EW – PP 106 to PP 107



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Manikandan,Murugan

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer
